



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D212-664-101
Job Sheet 170333-C



03735

Part No: D212-664-101

Job Qty: 1 ea

Part Name: Fwd Crosstube - High



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/15/18

Job Tracking No:

Due Date: 1/31/18

Created By: Mario Poulin

Type: SOLD

Description:

Note: DWG REV E IPP Rev:E 04.02.16 Reformat KJ/DS IPP Rev:F 06-03-29 Remove Comments on Pick List JLM IPP
Rev:G 07-04-30 As per Rev C JLM IPP Rev:H 11.04.26 inspection strip ecn 11-549 EC verf by:DD IPP REV:I
14.05.27 AS PER ECN 14-570 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		1/30/18	0.00	0.00	Start Up Stores/Pkg-1		DPZ
110	Packaging	1 pcs		1/30/18	0.00	0.00	Packaging1-3		GP
120	CNC Bend Crosstubes	1 pcs		1/30/18	3.11	2.22	CNC Bend Crosstube		TW
130	QC	1 pcs		1/30/18	0.00	0.00	QC15		GP
140	Crosstubes	1 pcs		1/30/18	0.00	0.67	Crosstubes-1		GP
150	HandFXtube	1 pcs		1/30/18	0.00	0.98	HandFinish5		GP
160	QC	1 pcs		1/30/18	0.00	0.00	QC7-1		GP
165	QC	1 pcs		1/30/18	0.00	0.00	QC5		GP
170	Outsource	1 pcs		1/30/18			SKY002-VC	Outsource 2	AT 1/15/18
180	Packaging	1 pcs		1/30/18	0.00	0.00	Packaging2		AT 1/15/18
190	QC	1 pcs		1/30/18	0.00	0.00	QC5		38
200	SprayPaint	1 pcs		1/30/18	0.00	0.25	Spray Paint		✓ AS 08 MAR 19 2018
210	QC	1 pcs		1/30/18	0.00	0.00	QC14		✓ AS JUN 04 2018
220	Crosstubes	1 pcs		1/31/18	0.00	1.69	Crosstubes-1		✓ AS JUN 04 2018
230	QC	1 pcs		1/31/18	0.00	0.00	QC5		DAS 13-06-07
240	Packaging	1 pcs		1/31/18	0.00	0.00	Packaging1-3		UN 07 2018
250	QC	1 pcs		1/31/18	0.00	0.00	QC4		SRB DAS
255	DC	1 pcs		1/31/18	0.00	0.00	DC		SRB 28
260	Packaging	1 pcs		1/31/18	0.00	0.00	Packaging3-1		DAS 9-89
270	QC21-FG	1 Ea		1/31/18	0.00	0.00	QC21		21 180619

Part Op 120 - Bend tube as per Dwg D212-664-141 using CNC bender program 212-fw and Folio D212-664-101

Descriptions: 140 - "1-Drill pilot holes in tube as per Dwg D212-664-141 using drill Jig DT8548 & DT8549, using drill table DT8577, set-up towers in hole #7 as per QSI 10 2-Ream hole to finish size in tube as per Dwg D212-664-141 using drill Jig DT8548 & DT8549. Check dimensions between holes, both sides on both cuffs, to ensure alignment with saddle holes. 3-Scribe part # and batch # using vibrating stylus as per Dwg D212-664-141 4-*** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D212-664-141"

150 - ***IMMEDIATELY AFTER GRINDING***

170 - *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038 LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order

180 - Ensure copy of NDT results attached to work order.

190 - *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Inspect for damage & ensure results are as per Dwg D212-664-141

200 - *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** 1-Prime inside & outside crosstube as per QSI 005 4.2 BATCH: 2- After painting remove masking and apply matte clear coat per QSI005 4.2 3- MASK

Prime 138687 Clear P.038689 Paint 138793
Prime 138847 138832 PAINT 138863

Plex 1/15/18 10:02 AM dart.poulin.mario

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐				

UNDERSIDE OF CROSSTUBE AS SHOWN ON DWG BEFORE PAINTING 4 -Paint Outside of Tube as per Dart QSI 005 4.2

210 - Then, Wrap in plastic bag to protect from scratches

220 - *****LAY DOWN CROSSTUBE ON TABLE AND PUT DT10302 PINS IN SADDLE HOLE FACING UP, USE HOLE IN TAPE MEASURE TO PUT IN PINS FOR LOCATING CENTER OF CROSSTUBE. ***** 1- Abrade mating surfaces of support and crosstube with 180 grit sandpaper, clean the area with MEK or equivalent as per dwg 2- Install supports with Proseal 890 per D212-664-141 and QSI 015 A/R Proseal 890 Batch: ~~138708~~ EXP: ~~5/18~~ PROSEAL CURE TIME 72 HOURS: Start: ~~3/24~~ Finish: ~~5/18~~ 3- Install clamps

with rubber cushion (ENSURE CLAMPS ARE INSTALL ON TOP SIDE OF CROSSTUBE) using DT9565 as per Dwg D212-664-141. ***Torque all clamps to 80-100 IN-LBS.*** ~~138708~~ exp 9/18 18-6-4 → 18-6-7

230 - ***RE-CHECK TORCQUE ON CLAMP AFTER PROSEAL HAS CURED FOR 72HOURS AS PER DWG.***

250 - ***VERIFY BY _____ BATCH # TO MATCH W/O _____

255 - Photocopy bluefile and create labels as per PPP D212-664-101 CHG006

260 - Identify and pack for shipping as per PPP D212-664-101 Location : FG094

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D212-664-101TRN	1	2	0	0
240-Packaging	AN6-35A 5017096X3 501384082 2 X17	4	81	0	0
	AN6-36A 5056006	4	69	0	0
	D3428-1 5038068	1	15	0	0
	MS21042L6 5041168	6	346	0	0
	NAS1149D0663J 5043782	18	1,355	0	0
220 Crosstubes	D2893-1 5053368 17255 5077238	2			
	MS21920-25 5024697 4	4			

Part Specifications

D3595063-450 ~~5098868~~ ~~4~~ ~~5062603~~

Specifications could not be found.



Container No: S047035



Part: D212-664-101

Job No: 170333-C

Serial No/Batch: S047035

Revision:

Inspector:

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CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

5/18 10:02 AM dart.poulin.mario

Date: 03/01/18

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date : _____		Step #: _____		QTY Effective : _____		MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval			
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Item	Qty -141	Qty -141B	Qty -141F	Part Number	Description
1	X			D212-664-141	CROSSTUBE ASSEMBLY (205/212/412 HIGH FWD)
2		X		D212-664-141B	CROSSTUBE ASSEMBLY (214 HIGH FWD)
3			X	D212-664-141F	CROSSTUBE ASSEMBLY (205/212/412 HIGH FWD) (ANODIZED)
4	1	1	1	D6005-128	CROSSTUBE
5	2		2	D2893-1	SUPPORT
6	4	4	4	D3595-063-450	RUBBER CUSHION
7		2		D5017-1	SUPPORT
8	4	4	4	MS21920-25	CLAMP (OR MS21920-26)
9	A/R	A/R	A/R	PROSEAL 890 B-2	SEALANT, AMS-S-8802 CLASS B-2

GENERAL NOTES:

- MATERIAL: MANUFACTURED FROM D6005-128
FINISHED LENGTH = 128.514±0.020
- FINISH -141 & -141B: a) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
b) PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
c) MASK UNDERSIDE OF CROSSTUBE AS SHOWN (ZN C6-2 / C6-3, HATCHED AREA)
d) PAINT OUTSIDE PER DART QSI 005 4.2
e) REMOVE MASKING AND APPLY MATTE CLEAR COAT
- FINISH -141F: a) ANODIZE PER MIL-A-8625, TYPE II, CLASS 1.
b) ALODINE (DO NOT ETCH) PER QSI 005 4.1.2
c) PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
d) MASK UNDERSIDE OF CROSSTUBE AS SHOWN (ZN C6-2 / C6-3, HATCHED AREA)
e) PAINT OUTSIDE PER DART QSI 005 4.2
f) REMOVE MASKING AND APPLY MATTE CLEAR COAT
- *NOTE: BETWEEN FINISHING OPERATIONS EXTREME CARE MUST BE TAKEN NOT TO CONTAMINATE OR DAMAGE FINISHED SURFACES.
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED.
- BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- IDENTIFICATION: SCRIBE DART PART NUMBER "D212-664-XXX" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS
- WEIGHT: D212-664-141/-141B/-141F = 33.6 lbs
- PART IS SYMMETRIC ABOUT CENTERLINE.
- EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.

MACHINING

- RUN CUTTER OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.

BENDING

- BEND PROGRESSIVELY WITH A MINIMUM OF 3 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 7.2% (BASED ON O.D.) IN LOWER HALF OF R35.5 BEND AND 6% (BASED ON O.D.) ON REMAINING TUBE.
- LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.

ASSEMBLY

- TO INSTALL D2893-1 / D5017-1 SUPPORT: ABRASE MATING SURFACE OF SUPPORT AND CROSSTUBE WITH 180-GRIT SANDPAPER AND REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY A 0.04" TO 0.07" THICK LAYER OF PROSEAL 890 CLASS B-2 (OR AMS-S-8802 CLASS B-2) SEALANT TO MATING SURFACE OF SUPPORT.
- INSTALL MS21920-25 CLAMPS (OR -26) WITH D3595-063-450 RUBBER CUSHIONS TO SECURE THE SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE ON TOP SIDE OF CROSSTUBE.
- TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING. PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER PROSEAL 890 SEALANT HAS CURED FOR 72 HOURS.

RELEASED
2014-05-26
WD

E	ADD -141F. D5017-1 WAS D2893-1 (-141B). PROSEAL WAS MAGNOBOND, NOTE 2: ADD INSPECTION WINDOW, NOTE 11: ALLOW 7.2% CRUSH, NOTE 15: ADD 72HR CURE AND RETORQUE FOR PROSEAL, ADD SHEET 3, CLAMPS REVERSED TO PREVENT CHAFING (B7-2, B7-3), BEND HEIGHT TOL. NOW 0.25 WAS 0.13 (C1-3), INCORP. DEO D-1/-2/-3	CP	14.04.01
D	REFORMAT/REVISE GENERAL NOTES/PART LIST: REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS; ADD -141B (ZN B4-2, D4-2); REMOVED REF & ADD TOLERANCES (ZN B4-3, C6-3, C6-3 & B6-3); RELOCATED FLAG #6 PER PAR 08-046 (ZN A5-3); MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4	RF	09.09.30
C	REMOVE -851 ABRASION STRIP; ADD MAGNOBOND 6388, CUSHION, REVERSE CLAMPS	PH	07.03.08
B	ADD HOLES FOR COMPATIBILITY WITH BHT/AA SKIDTUBES	PH	05.02.04
A	NEW ISSUE	CP	00.12.12
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	14.04.01		

DART AEROSPACE LTD
HAWKESSBURY, ONTARIO, CANADA

DRAWING NO. D212-664-141
REV. E
SHEET 1 OF 5
TITLE XTUBE ASSY (205/212/412 HI FWD)
SCALE NTS

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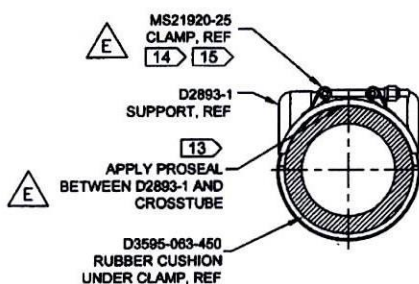
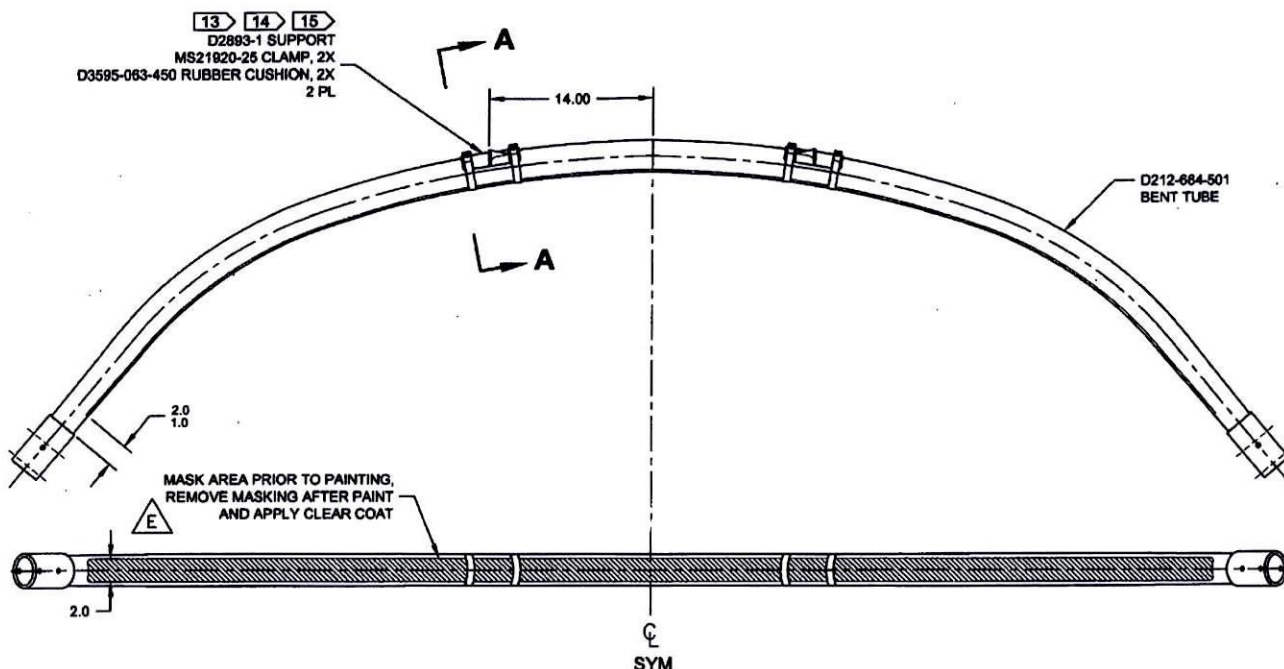
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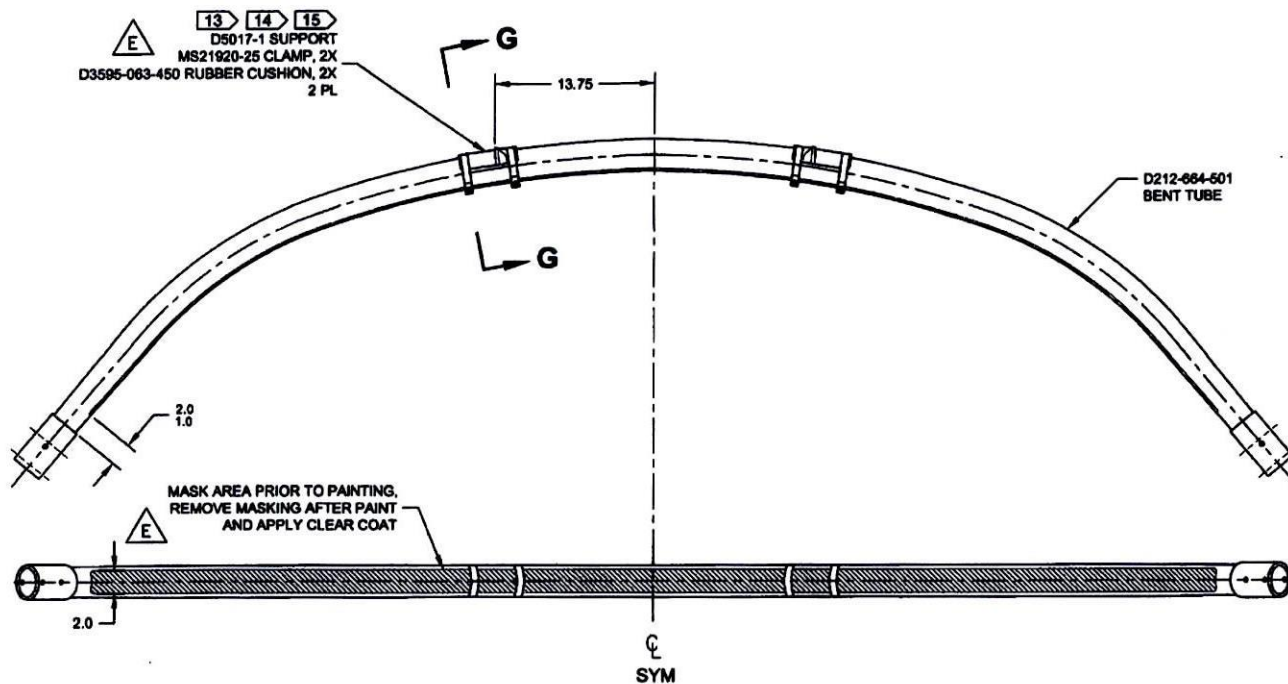
SECTION A-A
SCALE 4X

D212-664-141/-141F
ASSEMBLY DETAIL

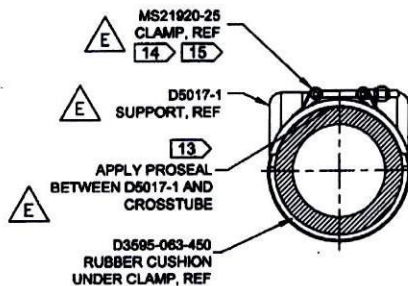
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2014-05-26
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DRAWN	<i>P</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>W</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>W</i>	D212-664-141	SHEET 2 OF 5
APPROVED	<i>W</i>	TITLE	SCALE
DE APPR.	<i>W</i>	XTUBE ASS'Y (205/212/412 HI FWD)	NTS
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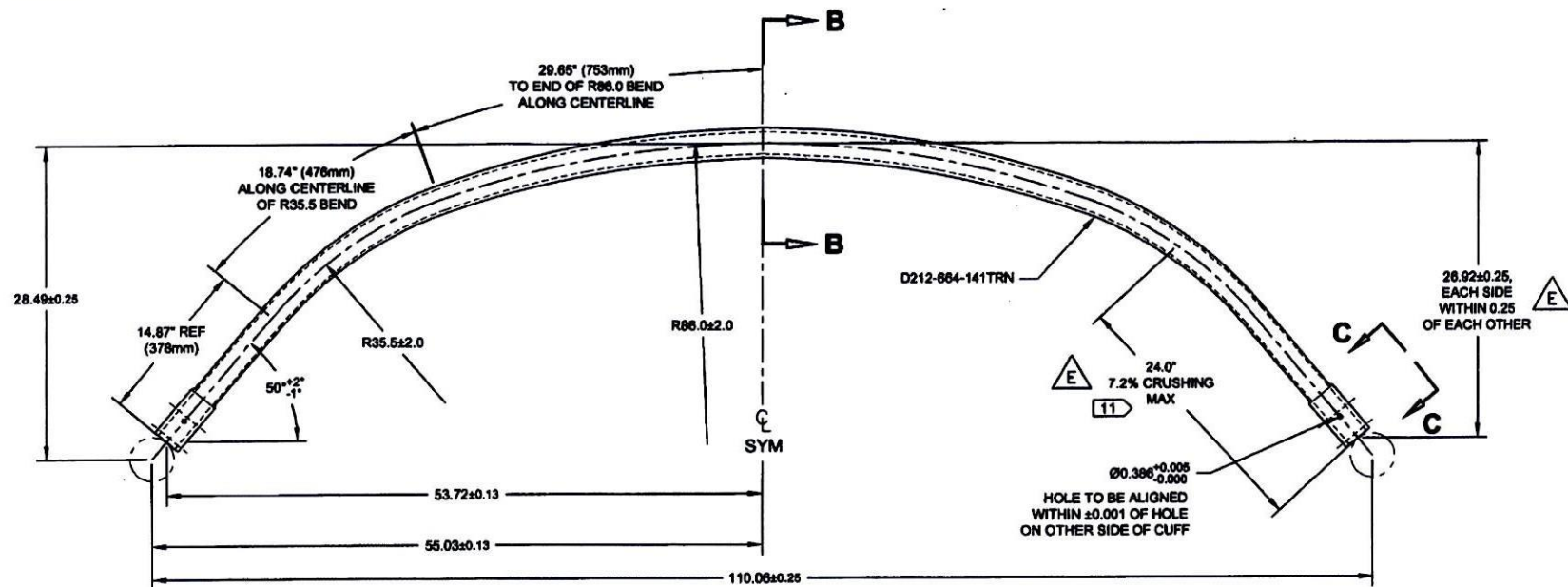
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ASSEMBLY DETAIL



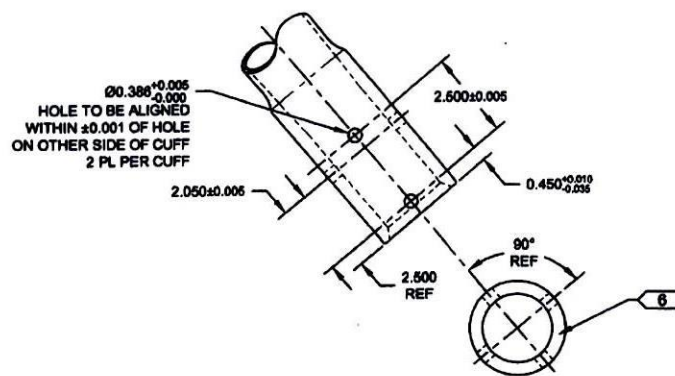
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RELEASED
2014-05-26

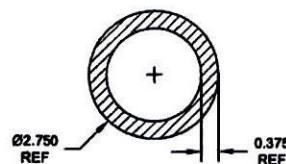
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MFG. APPR.		D212-664-141	SHEET 3 OF 5
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D212-664-501
BENDING AND DRILLING DETAIL 11



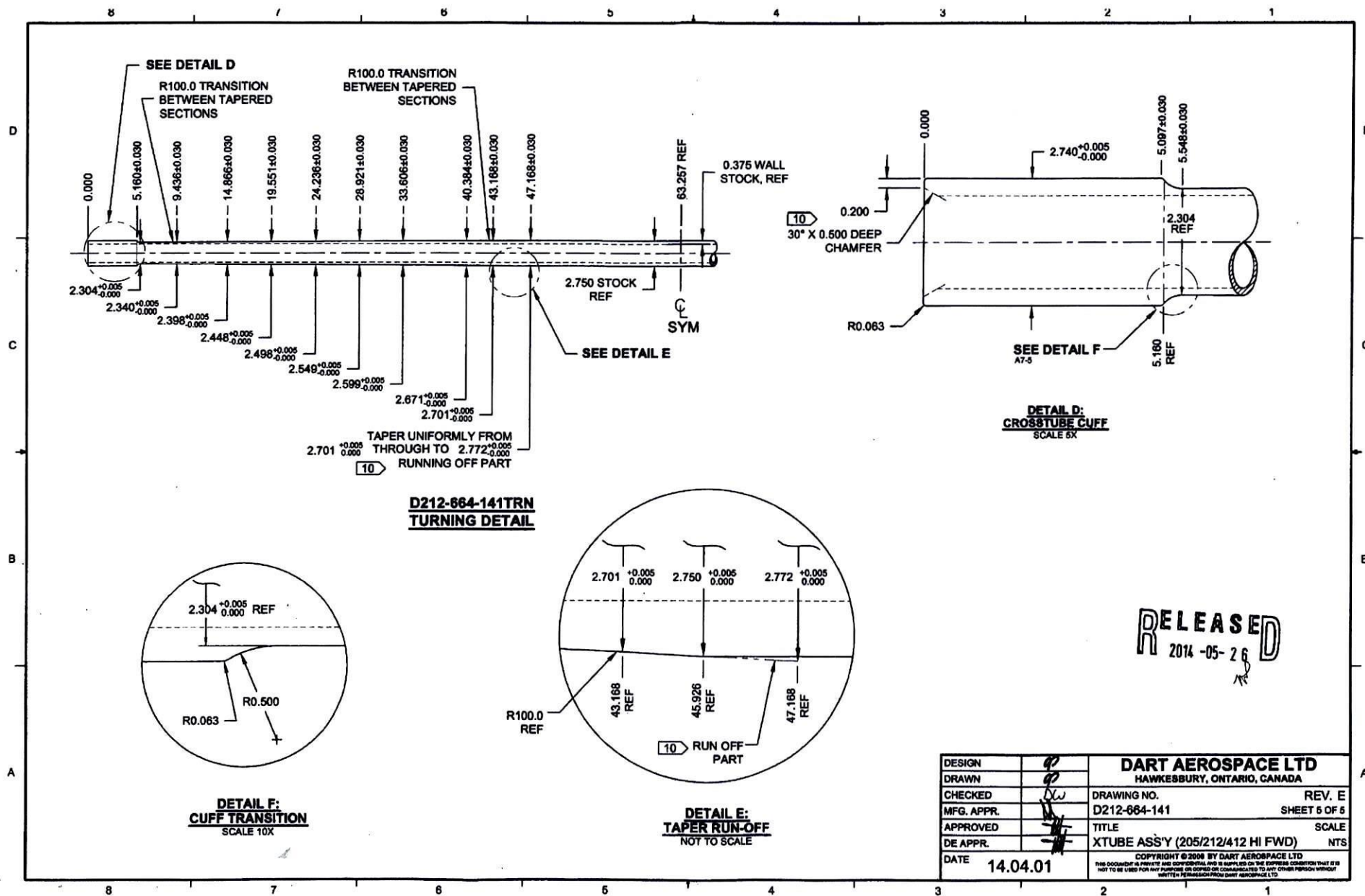
VIEW C-C: CUFF DETAIL
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SECTION B-B
SCALE 4X

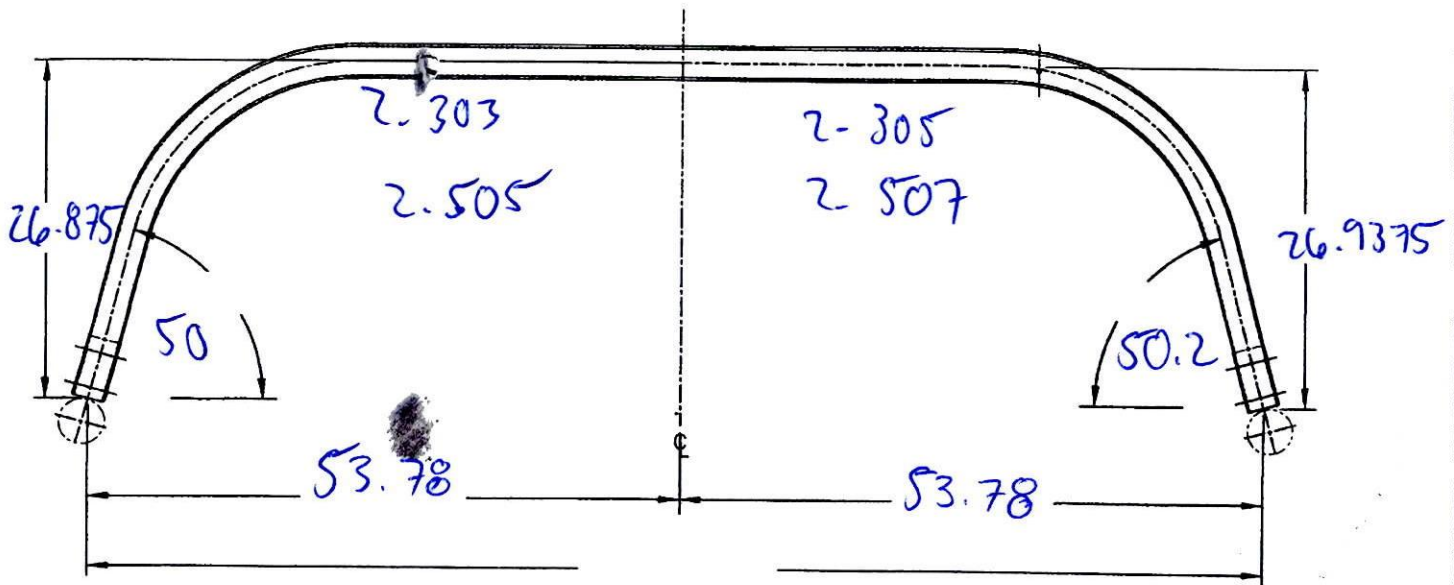
RELEASED
 2014-05-26

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D212-664-141	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		XTUBE ASS'Y (205/212/412 HI FWD)	NTS
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DART AEROSPACE LTD		Work Order:	
Description: Crosstube High Fwd (205/212/412)		Part Number:	D212-664-101
Inspection Dwg: D212-664-141	Rev: E		Page 1 of 1

Required Dimension	Min	Max
Height	26.67	27.17
1/2 Span	53.59	53.85
Angle	49	52
Total Span	107.18	107.7
Bending Passes	3	--
Crushing	--	7.2%



	Side A	Side B
Bending Passes	5	4
Crushing	4.2%	4.2%
Comments		

QC15 Inspection	TW
Date	18-03-01

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	08.04.21	Dwg Rev updated	KJ/JM	
C	10.04.01	Dwg Rev updated	KJ	
D	12.04.16	Added bending, crushing dimensions	KJ	
E	14.07.28	Revised max crushing %	KJ	
F	16.01.15	Revised Height min/max dimensions	KJ	



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Tel (613) 632-5200

PURCHASE ORDER

PO039164

Supplier: SKY002-VC
Skysservice
6120 Midfield Road
Mississauga
ON
L5P 1B1 Canada
Phone: 905-678-5636
Fax: 905-678-5841

PO No: PO039164
PO Date: 3/2/18
Due Date: 3/5/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Phone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	170333	D212-664-101	Fwd Crosstube - High *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038 LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order	Firmed	3/5/18	1 pcs	0 pcs	1 pcs	\$152.50/pcs	\$152.50
	170333-A			Firmed	3/5/18	1 pcs	1/0 pcs	1 pcs	\$152.50/pcs	\$152.50
	170333-B			Firmed	3/5/18	1 pcs	1/0 pcs	1 pcs	\$152.50/pcs	\$152.50
	170333-C			Firmed	3/5/18	1 pcs	1/0 pcs	1 pcs	\$152.50/pcs	\$152.50
	172296			Firmed	3/5/18	1 pcs	1/0 pcs	1 pcs	\$152.50/pcs	\$152.50
	172297			Firmed	3/5/18	1 pcs	1/0 pcs	1 pcs	\$152.50/pcs	\$152.50
Sub Total:						6	0	6		\$915.00

Grand Total: \$915.00

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retension of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

**skyservice****Work Order Traveler**
Sky Service F.B.O. Inc.

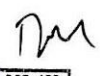
10105 Ryan Avenue, Dorval, Quebec, H9P 1A2

TCCA AMO 53-89 / EASA 145.7142 / BDA AMO 385

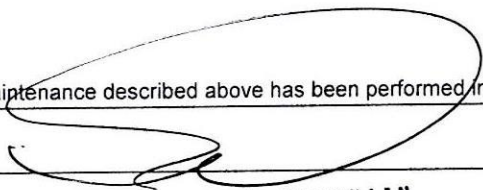
WO #: MWO35190	Customer: Dart Aerospace Ltd.	Dept: NDT YUL	Reference: PO039164
Descr:	PN:	S/N:	Qty: 1
Make:	Model:	Reg:	A/C S/N:
TSN:	CSN:	TSO:	
Task: UNSCHEDULED			Sequence: 1

Work Required:

CARRY OUT NDT ON 6 FWD CROSSTUBES , P/N# D212-664-101 , J/S# 170333 , 170333-A ,
170333-B , 170333-C , 172296 , 172297

Action Taken:						Date:	Initial/Stamp:
LPI C/O IAW ASTM E-1417M-13 ***NO CRACK FOUND*** PEN. ZL-56, MPO13600, CLEANER SKC-S MPO13923 , DEV. MPO11715 , UV LIGHT M-20142						MAR 02 2018	 
Description	Location	P/N	Qty	Batch	S/N Off	S/N On	

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature: 	ACA/SCA Stamp 	Date: MAR 02 2018
Name: RAFIK MELIKIAN		

Non-Conformance Report

Reviewed
DQA:
Date:

Printed on: Wednesday, May 02, 2018

Details			
Raised Date 5/2/2018	Status Open	Owner Menard, Jean-Luc	Number NCR18-6846
Target Date	Standard	Severity	
Process Employee finding		Audit	
Raised By Person Duval, Patrick	Raised Against (Department or Supplier)	Fault Category General\Temperature\Cure	
Details Found on D212-664-101, after installation that paint was peeling off. Root cause, no accelerator was added to the paint. Following batch are affected; S046420, S047060, S047035, S046393			
Keywords		Product D212-664\D212-664-101	
Document		Root Cause	
Closed By	Closed Date	Resolution	

Root Cause			
Target Date 5/12/2018	Owner Downing, Eric M	Closed Date	Closed By
Details			

Actions			
Number	Owner	Target Date	Completed Date
Details		Response	

Corrective Action			
Target Date 5/12/2018	Owner	Closed Date	Closed By
Details			

Actions

Number	Owner	Target Date	Completed Date
Details		Response	
1	Sheldon, Andrew	5/16/2018	AB JUN 04 2018
Remove support, strip paint off crosstube using paint stripper, alodine if necessary, prime, paint, and reinstall support to be completed on S046420, S047060, S047035, S046393			

Implementing Corrective Action

Target Date	Owner	Closed Date	Closed By
5/12/2018			
Details			

Actions

Number	Owner	Target Date	Completed Date
Details		Response	

Verification & Review

Target Date	Owner	Closed Date	Closed By
	Downing, Eric M		
Details			

Actions

Number	Owner	Target Date	Completed Date
Details		Response	

PAGE 1 OF 1

Description: CROSSTUBE INSTALLATION, HIGH FWD

H:\Forms\Engineer\Approved Eng Online\CHGREC revB